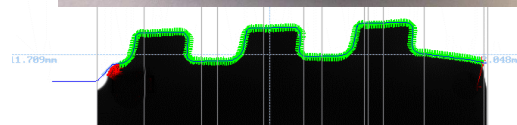
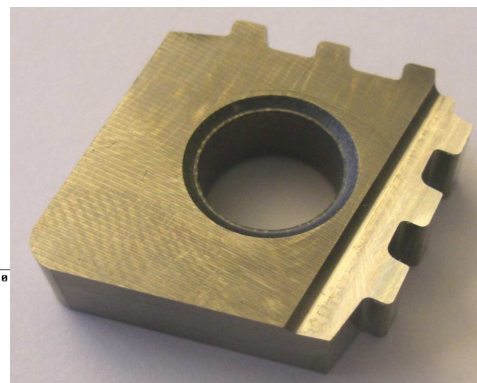

















Threadform Insert multitooth Z2

A08-010

The multitooth Threadform Insert is a high precision turning insert used in the oilfield. The precisions required are for some profile parts usually less than 0.01 mm. The roughing and pregrinding are important operations in order to conserve the finishing wheel over the complete batch of inserts. The DXQ Profile Program of Quinto supports the shape 1A1 and 1V1 wheels used for the roughing and considers the width as well as the corner radii on both sides. For pregrinding and finishing VSV grinding technique is used.



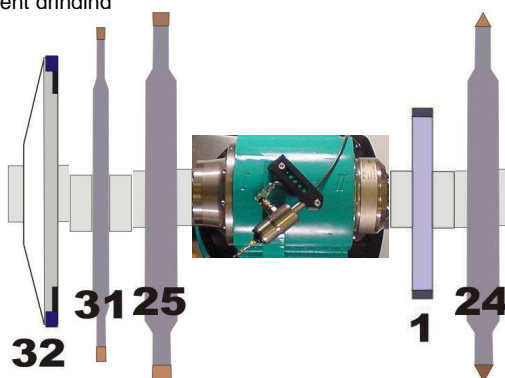
1. Cycletime for Production

Tool specifications BxH 30x30 mm, rhombic, threadform on 2 sides Material CARBIDE									
Operations									
Feed [mm/Min]	2000	120	20	20	60	60	9000	100	100
Power [kW]		1	3	2	1	1	1	1	1
Cutting feed [m/s]		12	22	22	22	24	24	24	24
Used wheels									
Grinding time [s]	15	45	142	128	63	63	8	400	11
Total cycle time	14 Min 35								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

32	12C9 Ø250 D64
25	1A1 Ø300 D64
31	14A1 Ø250 D64
24	14V1 Ø300 D64
26	14V1 Ø300 D46
1	1A1 Ø125 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 4

responsible engineer: OP,27.3.09

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